

Work Order ID 144501

April 19, 2016 11:41:27 AM

Page 1

Item ID: D3508-3

Revision ID:

Item Name: Wearplate Fwd Center

Start Date: 4/25/2016 Start Qty: 8.00

Required Date: 5/6/2016 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: SHDate: 20160419

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

NR1

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D3508

Rev C

100

0.00

100

Waterjet

FLOW WATER JET

Memo

1.20

FLOW CNC Waterjet

1-Cut as per Dwg D3508 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary

(8)

De 16/05/16

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.08

Quality Control

(8)

De 16/05/16

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.16

Quality Control

(8)

DAS
38
9-89
MAY 12 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 2

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 Revision ID: Stop ***NS2***
 Item Name: Wearplate Fwd Center
 Start Date: 4/25/2016 Start Qty: 8.00 ***8*** Cust Item ID:
 Required Date: 5/6/2016 Req'd Qty: 8.00 ***8*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Brake NC Brake NC	NC BRAKE Memo 1-Form on brake using DT8326 and DT8261as per Dwg D35082-Form joggle as per Dwg D3508 Using DT8158	0.10 0.16			DAS 30 9-89	(8)			MAY 12 2016
140 *140* QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.16				(8)			DAS 30 9-89 MAY 12 2016
150 *150* Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per OSI005 4.3 M 130746 Memo START TIME: <u>2:20</u> FINISH TIME: <u>2:58</u> OVEN TEMPERATURE: <u>320</u>	0.00 0.16				8	φ1605-17.		DAS 34 9-89

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

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Page 3

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Revision ID: Stop ***NS2***
Item Name: Wearplate Fwd Center
Start Date: 4/25/2016 Start Qty: 8.00 ***8*** Cust Item ID:
Required Date: 5/6/2016 Req'd Qty: 8.00 ***8*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	QC3- Inspect Part Finish	0.00							DAS 38 9-09
160									
QC	Memo	0.08							
Quality Control									

MAY 18 2016

170 Identify as per dwg & Stock Location: 172-002 0.00
170
Packaging Memo 0.08
Packaging LOCATION : FP002

180 QC21- Final Inspection - Work Order Release 0.00
180
QC Memo 0.80
Quality Control

X 2 of 2 16/05/12

16/5/19

MAY 19 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By _____ Lead hand / Supervisor Approval Verification _____ QC / QA Coordinator Approval _____		
Description Work Order Deviation				Disposition					
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		OTHER : ☐							

Picklist Print

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Parent Item: D3508-3

D3508-3

Parent Item Name: Wearplate Fwd Center

Start Date: 4/25/2016

Required Date: 5/6/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A New Issue 06-06-20 JLM
IPP Rev:B Now SS as per Rev B 06-12-15 JLM
IPP Rev:C Rev C dwg 07-12-06 DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S20GA		Purchased		No		100	sf	133.2210	0.734	6.181053			

M304S20GA

304/316 .040 Sheet

pc 16/05/12

Location

Loc Qty

Loc Code

MAT020

130

m134067

31.8

m134399

34.2

m134495

64

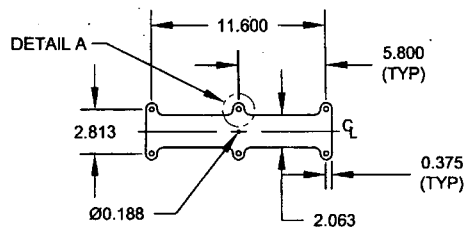
MAT20

3.221

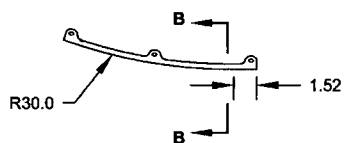
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3.221

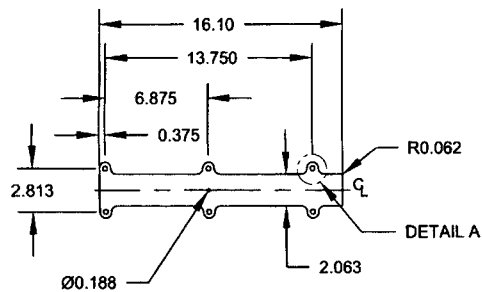
6.5



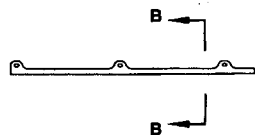
D3508-1 FLAT PATTERN



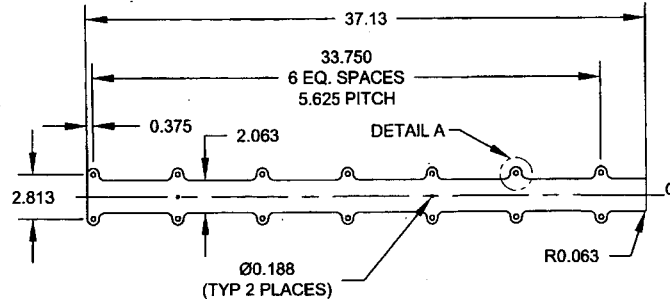
D3508-1 BENDING DETAIL
(MAKE FROM D3508-1F)



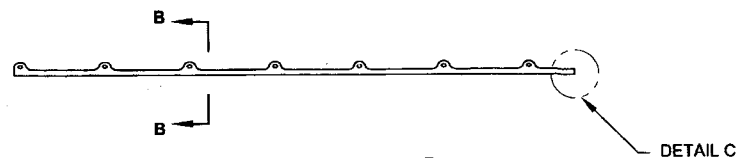
D3508-7F FLAT PATTERN



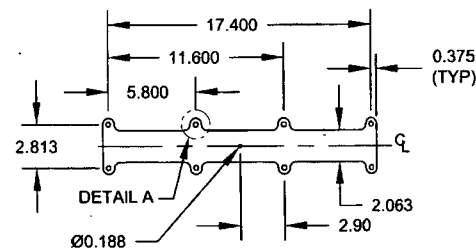
D3508-7F BENDING DETAIL
(MAKE FROM D3508-7F)



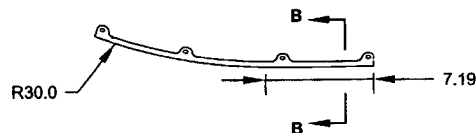
D3508-3 FLAT PATTERN



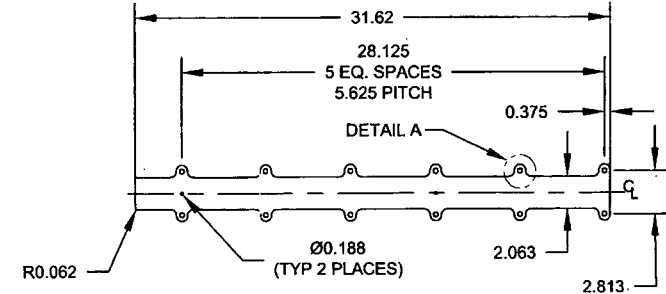
D3508-3 BENDING DETAIL
(MAKE FROM D3508-3F)



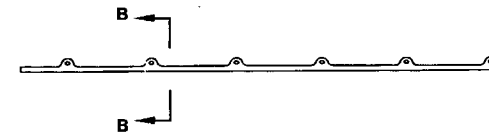
D3508-9F FLAT PATTERN



D3508-9F BENDING DETAIL
(MAKE FROM D3508-9F)



D3508-5 FLAT PATTERN



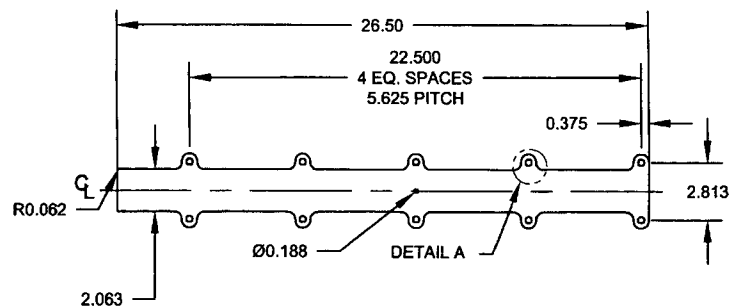
D3508-5 BENDING DETAIL
(MAKE FROM D3508-5F)

NOTES:

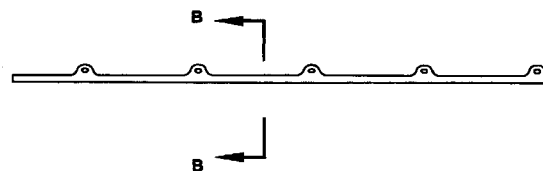
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 20 GAUGE (0.038 THICK)
(REF. DART MATERIAL SPEC M304S20GA)
- 2) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER DART QSI 005 4.3
- 3) WELD PER DART QSI 004
- 4) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) BREAK SHARP EDGES: 0.005 TO 0.015
- 7) IDENTIFICATION: NONE
- 8) WEIGHT: D3508-1 - 0.47 lbs, D3508-3 - 0.95 lbs, D3508-5 - 0.77 lbs,
D3508-7 - 0.39 lbs, D3508-9 - 0.45 lbs, D3508-11 - 0.64 lbs
D3508-13 - 0.25 lbs

RELEASED
07-11-16

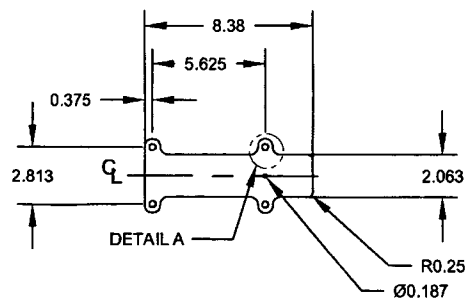
C	ADD -9/-11/-13 MOVE TAB OUTBOARD (2.813 WAS 2.733) CHANGE DRAWING FORMAT	PH	07.04.20
B	CHANGE STAINLESS STEEL, WIDEN	PH	06.10.27
A	NEW ISSUE	PH	06.04.21
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>[Signature]</i>	DART AEROSPACE USA, INC	
DRAWN	<i>[Signature]</i>	PORT HADLOCK, WA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3508	SHEET 1 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	WEARPLATE	1:8
DATE	07.04.20	COPYRIGHT © 2007 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	



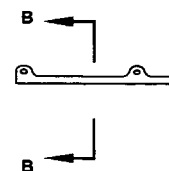
D3508-11F FLAT PATTERN



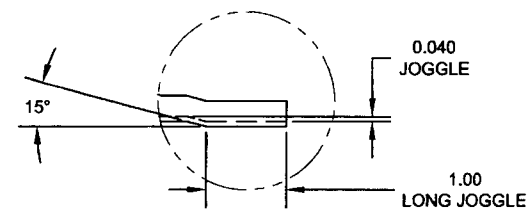
D3508-11 BENDING DETAIL
(MAKE FROM D3508-11F)



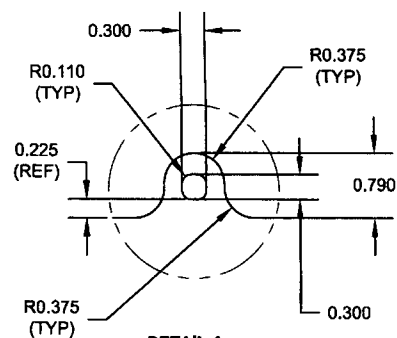
D3508-13F FLAT PATTERN



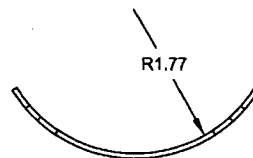
D3508-13 BENDING DETAIL
(MAKE FROM D3508-13F)



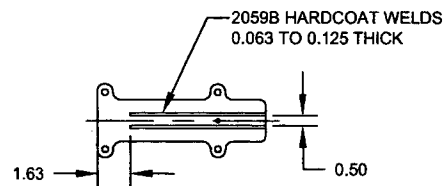
DETAIL C
(SCALE 1:2)



DETAIL A
(SCALE 2:3)



SECTION B-B
(SCALE 2:3)



D3508-13 WELDING DETAIL

RELEASED
07-11-16

DESIGN	PH	DART AEROSPACE USA, INC	
DRAWN	PH	PORT HADLOCK, WA	
CHECKED	PH	DRAWING NO.	REV. C
MFG. APPR.	PH	D3508	SHEET 2 OF 2
APPROVED	PH	TITLE	SCALE
DE APPR.	PH	WEARPLATE	1:6
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DART AEROSPACE LTD		Work Order:	144501
Description: Wearplate		Part Number:	D3508-3
Inspection Dwg: D3508	Rev: C	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.063	+/-0.010	2.065	/		V: D-02	
2.813	+/-0.010	2.812	/		Tape	
0.375	+/-0.010	.377	/			
5.625	+/-0.010	5.625	/			
33.750	+/-0.010	33.750	/			
37.13	+/-0.030	37.13	/			
Ø0.188	+0.005/-0.001	Ø.191	/			
0.300	+/-0.010	.305	/			
0.300	+/-0.010	.304	/			
0.038	+/-0.010	.035	/			

Measured by: <u>De</u>	Audited by: <u>DAS 38 9-89</u>	Prototype Approval:	N/A
Date: <u>11/05/11</u>	Date: <u>MAY 12 2016</u>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	08.04.15	New Issue	KJ/DD <u> </u>	<u> </u>